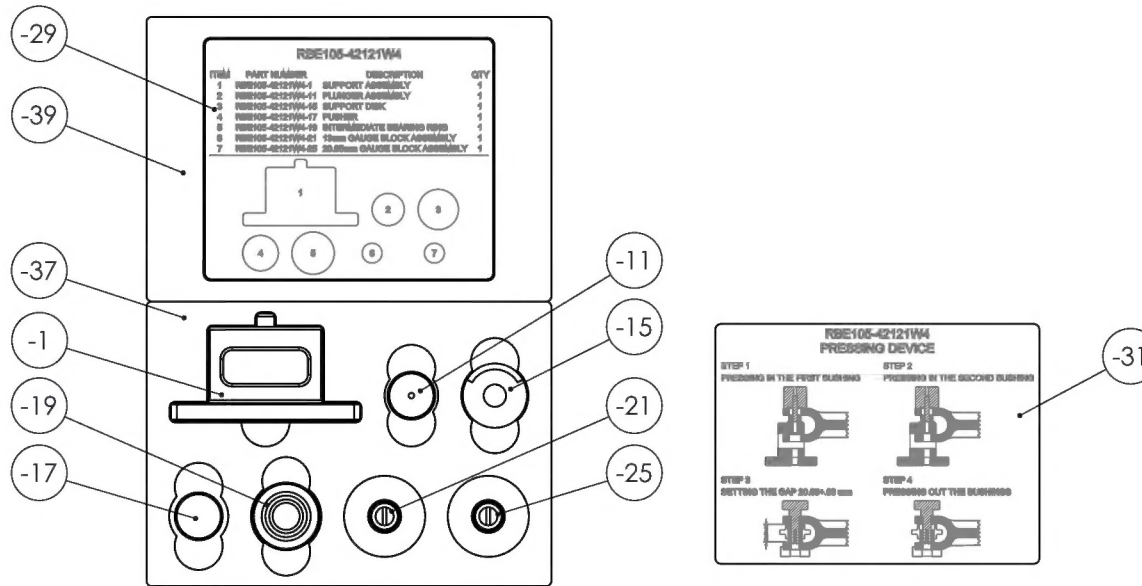


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	7/14/2017	DPD	JAG



ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				X		-1	1	SUPPORT ASSEMBLY			2
			X	1		-3		SUPPORT WELDMENT			3
			1			-5		SUPPORT BLOCK	4140/4142		4
			1			-7		SUPPORT PLATE	A36/1018/1020 HR		5
				1		-9		SUPPORT GUIDE BUSHING	4140/4142		6
		X				-11	1	PLUNGER ASSEMBLY			7
		1				-13		PLUNGER BASE	4140/4142		8
						-15	1	SUPPORT DISK	4140/4142		9
						-17	1	PUSHER	4140/4142		10
						-19	1	INTERMEDIATE BEARING RING	4140/4142		11
	X					-21	1	13mm GAUGE BLOCK ASSEMBLY			12
	1					-23		13mm GAUGE BLOCK	4140/4142		13
X						-25	1	20.65mm GAUGE BLOCK ASSEMBLY			14
1						-27		20.65mm GAUGE BLOCK	4140/4142		15
						-29	1	CONTENTS PLACARD			16
						-31	1	INSTRUCTION CARD	LAMINATED PAPER		17
			1		B/O	-33		PLUNGER ROD	STEEL	Ø5mm X 30mm (MCMaster-CARR #91595A372)	7
1	1				B/O	-35		GAUGE BLOCK PIN	STEEL	Ø2mm X 14mm (MCMaster-CARR #91595A030)	12, 14
					B/O	-37	1	BOTTOM FOAM	ETHAFOAM 220, BLACK	2.97 X 5.93 X 8.43 (CASE SOLUTIONS)	18
					B/O	-39	1	TOP FOAM	ETHAFOAM 220, BLACK	.72 X 5.93 X 8.43 (CASE SOLUTIONS)	19
					B/O	-41	1	CASE	PLASTIC	PELICAN #APP-1150-E	N/S
					B/O		1	DART PLACARD	ALUMINUM	RB41011	N/S
ASSY -25	ASSY -21	ASSY -11	ASSY -3	ASSY -1							

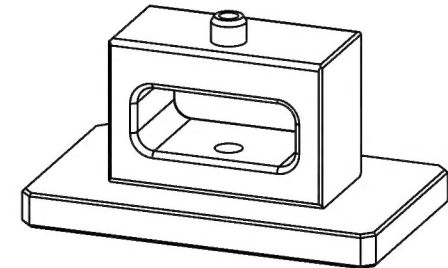
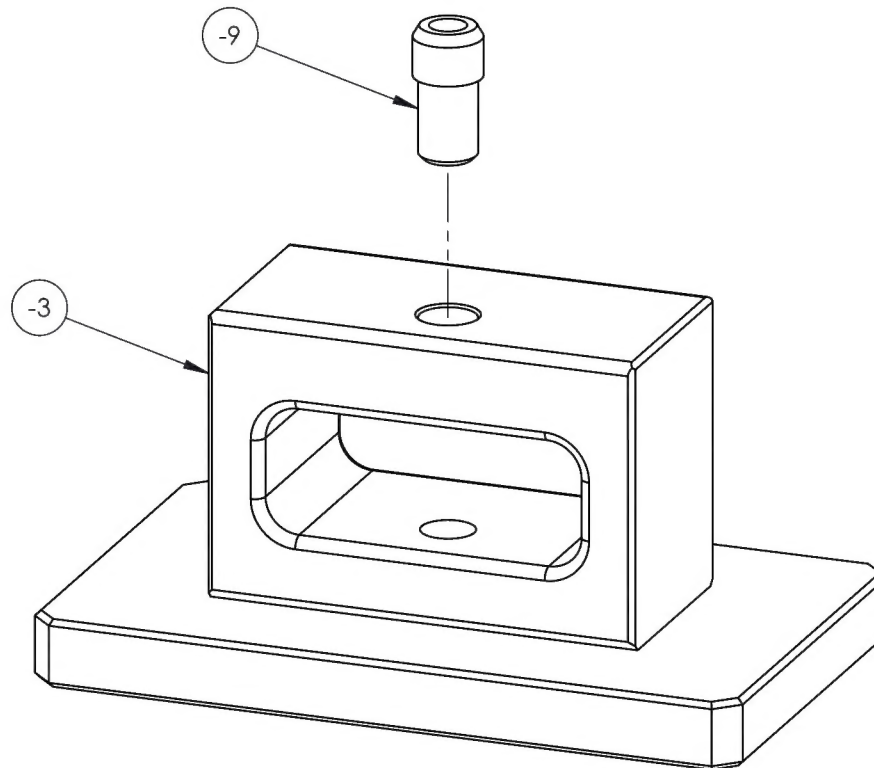
NOTE:
REF. AIRBUS T/N: 105-42121W4.

DART
AEROSPACE

TITLE		PRESSING DEVICE	
DWG NO.		RBE105-42121W4	
REV		1	
MATERIAL		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT		DIMENSIONS ARE IN INCHES	
FINISH		.XXX ± .005 FRACTIONS ± 1/8	
SPEC		.XX ± .01 ANGLES ± 5°	
DRAWN BY:		DD 06/30/2017	
CHECKED:		RJC 07/06/2017	
OPPS APPR:		AA 07/10/2017	
QA APPR:		JL 07/10/2017	
APPROVED:		JAG 07/20/2017	
SCALE		1:4	
DATE		6/30/2017	
SHEET		1 OF 19	

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REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

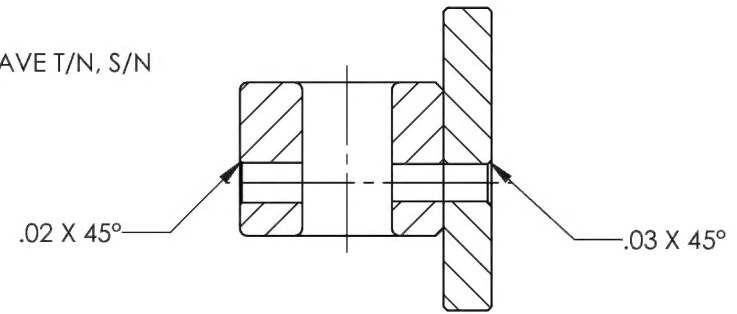
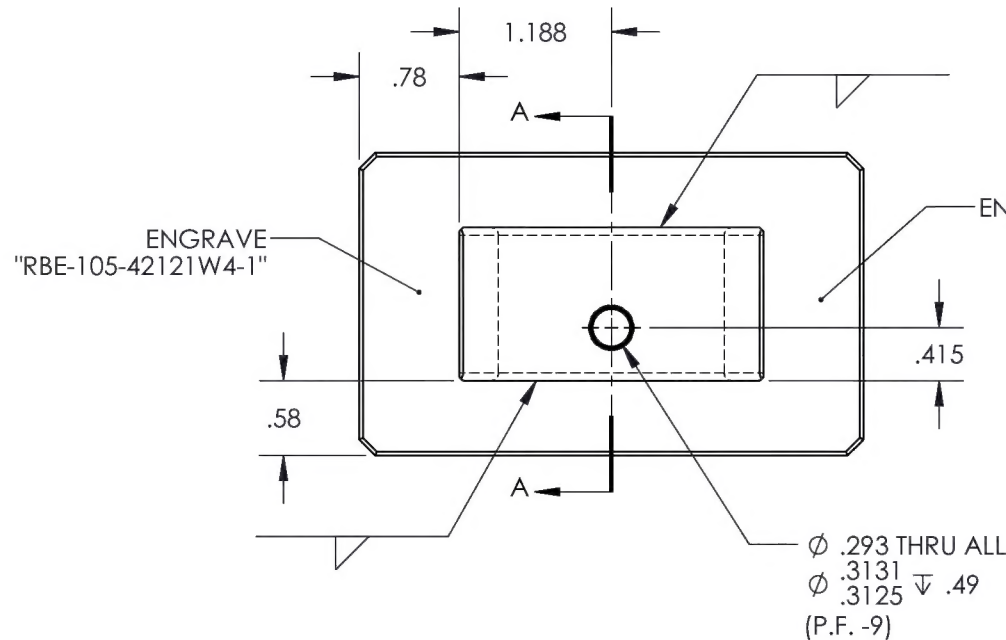
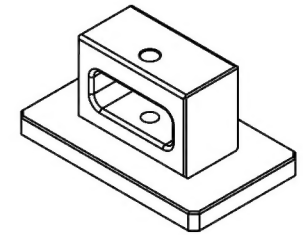


(1)
SUPPORT ASSEMBLY

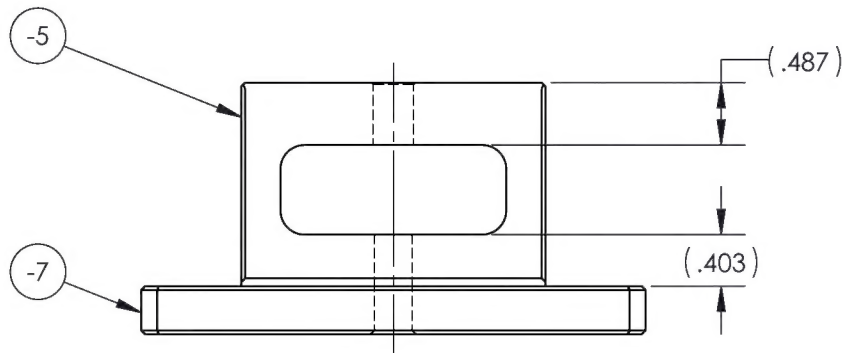
DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-1	REV 1
MAT'L REPT TREAT FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 07/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/10/2017	USED ON MODEL
QA APPR: JL 07/10/2017	APPROVED: JAG 07/20/2017 EC145, EC645, BO105, BK117
SCALE 1:1	DATE 6/30/2017 SHEET 2 OF 19

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SECTION A-A



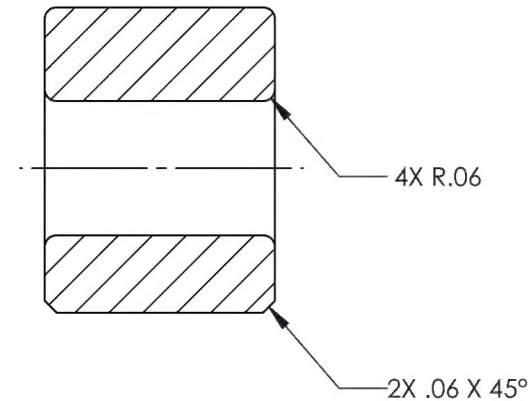
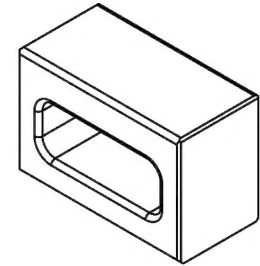
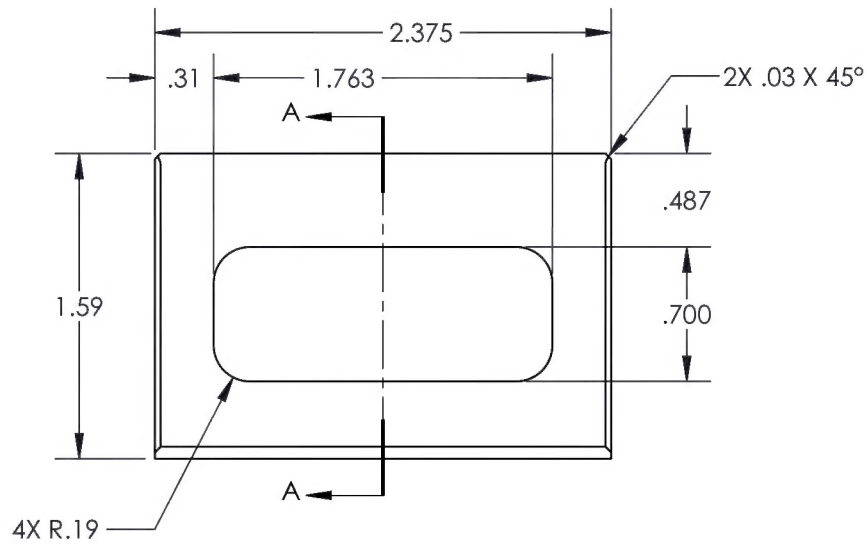
-3

SUPPORT WELDMENT

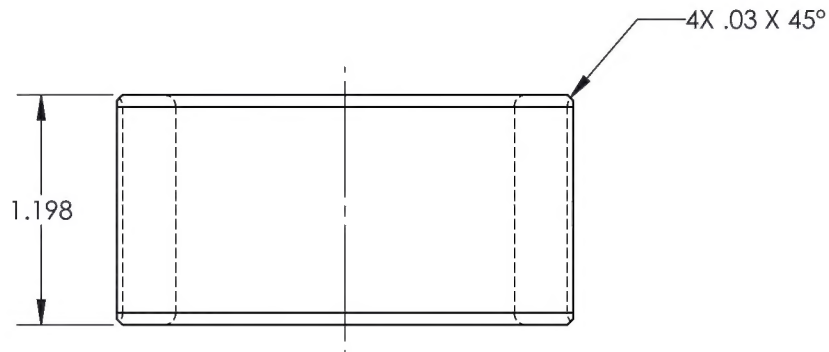
DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-3	REV 1
MAT'L HEAT TREAT FINISH SEE -1 SPEC DRAWN BY: DD 06/30/2017 CHECKED: RJC 07/06/2017 OPPTS APPR: AA 07/10/2017 QA APPR: JL 07/10/2017 APPROVED: JAG 07/20/2017	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
USED ON MODEL EC145, EC645, BO105, BK117	
SCALE 2:3	DATE 6/30/2017
SHEET 3 OF 19	

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				APPROVED



SECTION A-A



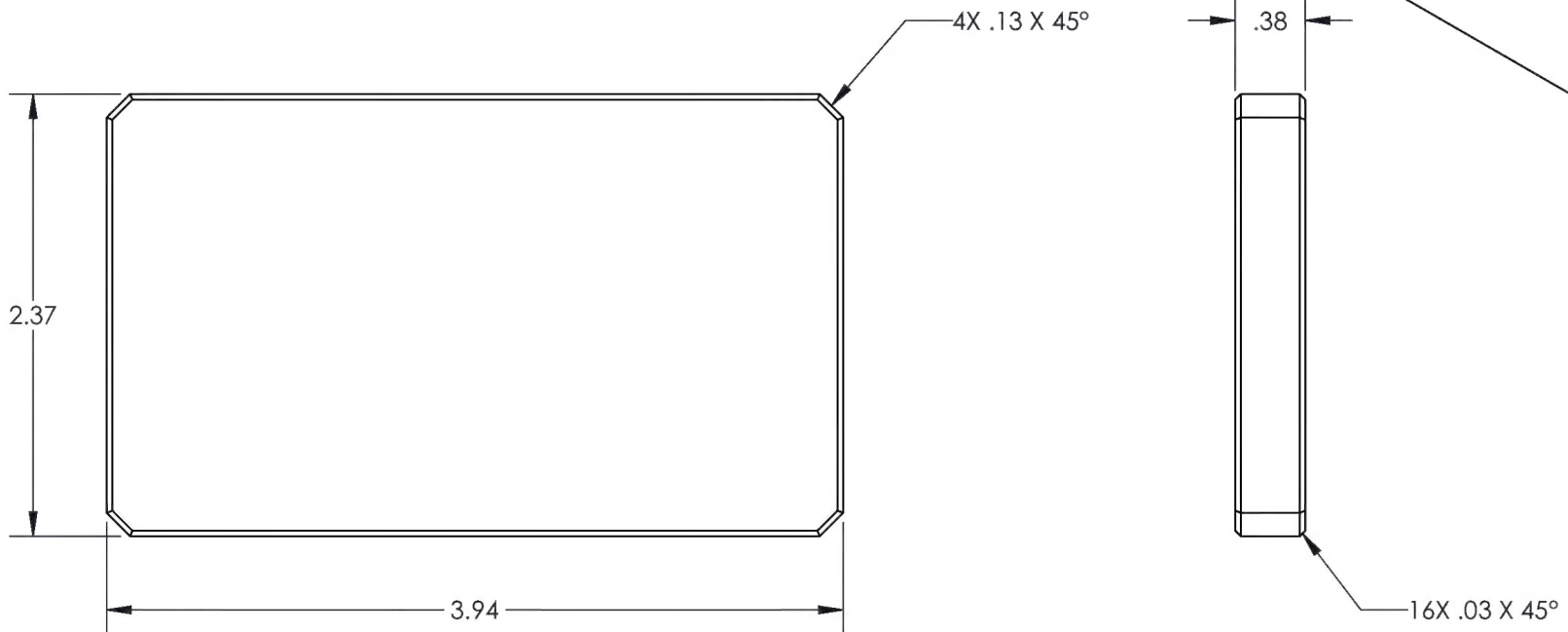
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SUPPORT BLOCK

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-5	REV 1
MAT'L 4140/4142 HEAT RC 28-34 FINISH SEE -1 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
DRAWN BY: DD 06/30/2017 CHECKED: RJC 07/06/2017 OPPS APPR: AA 07/10/2017 QA APPR: JL 07/10/2017 APPROVED: JAG 07/20/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE 1:1	DATE 6/30/2017
SHEET 4 OF 19	

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				APPROVED



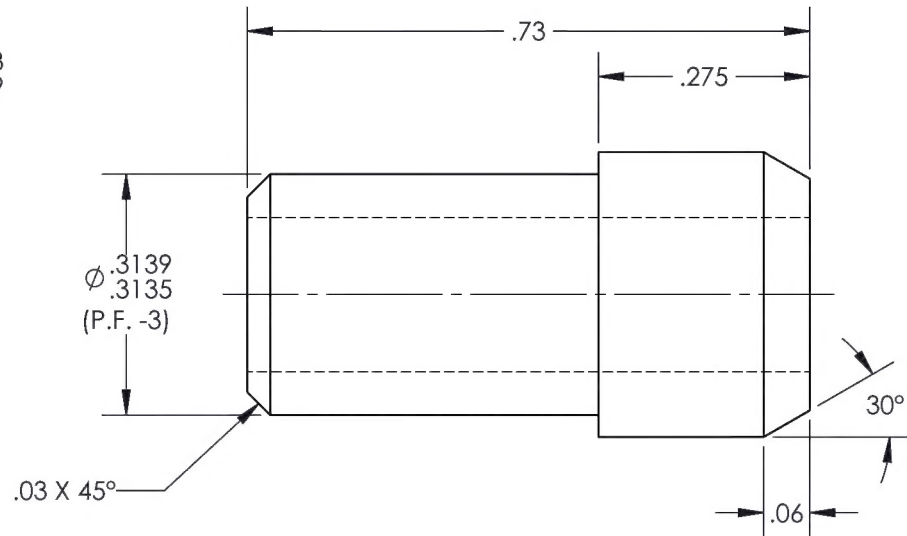
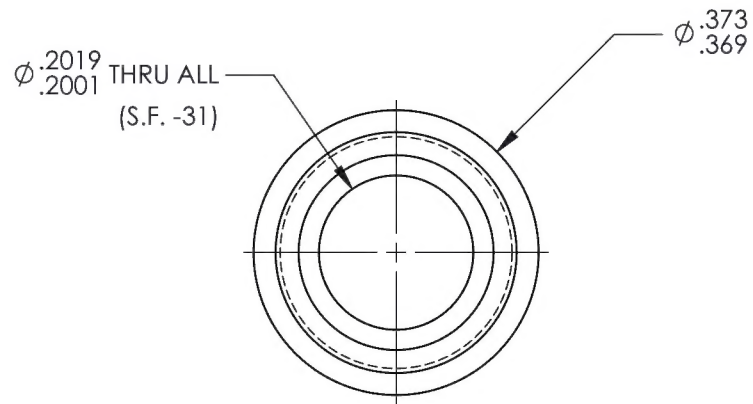
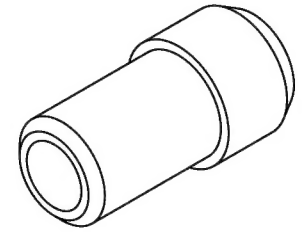
(-7)

SUPPORT PLATE

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-7	REV 1
MAT'L A36/1018/1020 HR	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DD 06/30/2017	1. BREAK ALL SHARP EDGES
CHECKED: RJC 07/06/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/10/2017	AFTER PLATING
APPROVED: JAG 07/20/2017	3. INTERPRET DIM AND TOL PER
SCALE 1:1	ASME Y14.5M-2009
DATE 6/30/2017	USED ON MODEL
SHEET 5 OF 19	EC145, EC645, BO105, BK117

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



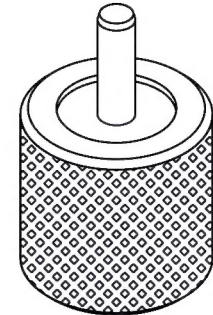
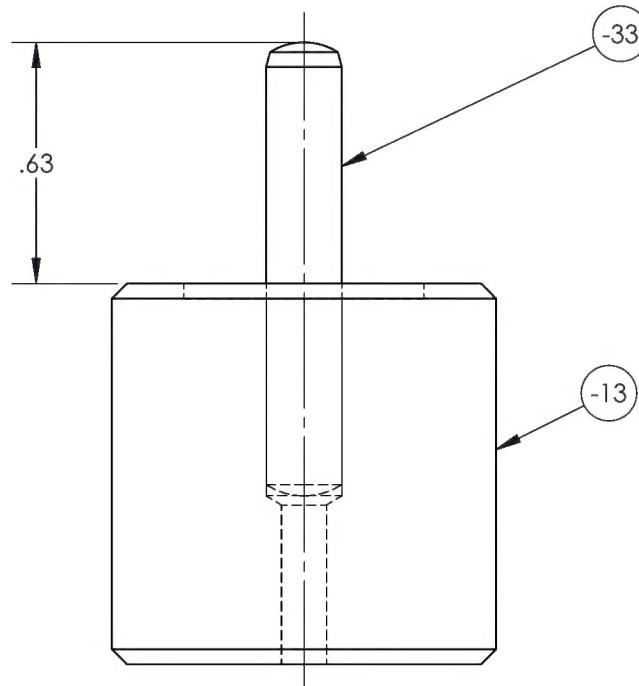
(9)

SUPPORT GUIDE BUSHING

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-9	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH SEE -1	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
DRAWN BY: DD 06/30/2017	.X ± .1 SURFACES = 125/
CHECKED: RJC 07/06/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/20/2017	AFTER PLATING
SCALE 4:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/30/2017	USED ON MODEL
SHEET 6 OF 19	EC145, EC645, BO105, BK117

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				APPROVED



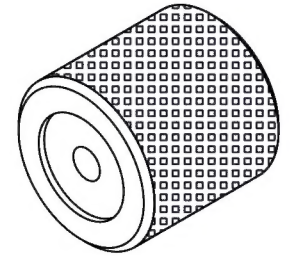
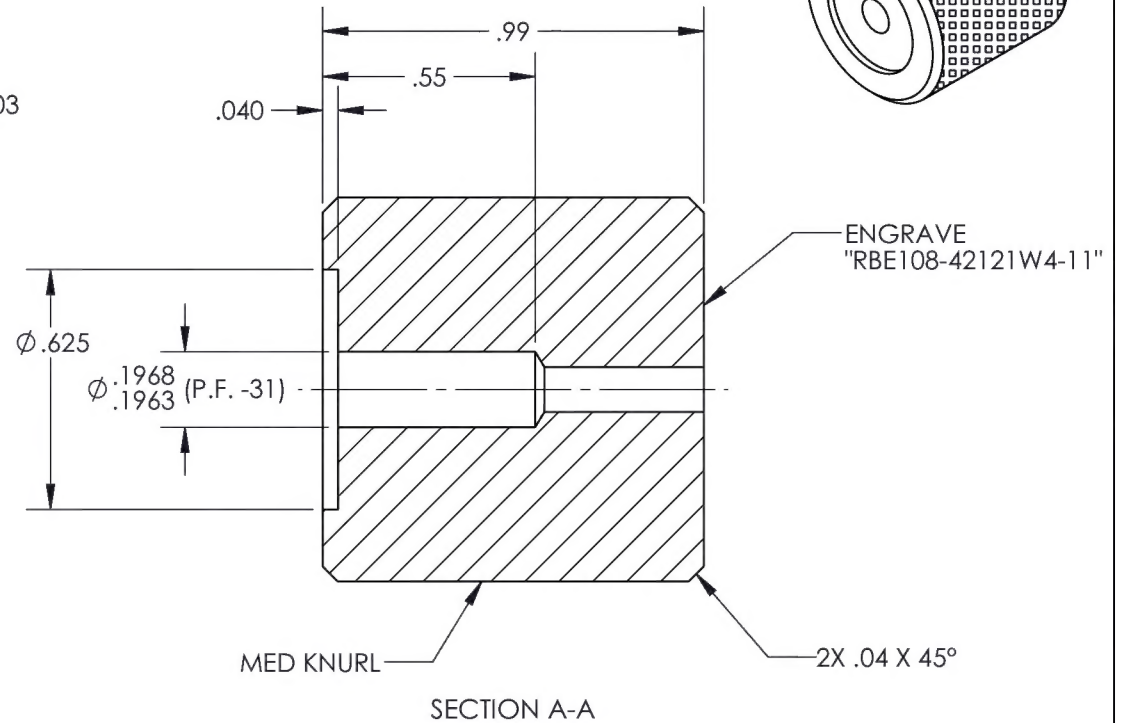
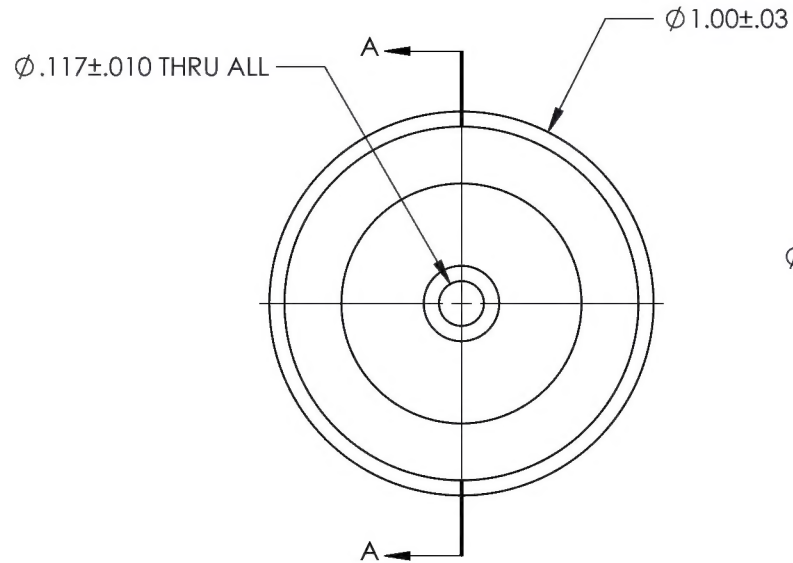
(-11)

PLUNGER ASSEMBLY

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-11	REV 1
MAT'L REPT TREAT FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 07/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/10/2017	USED ON MODEL
QA APPR: JL 07/10/2017	APPROVED: JAG 07/20/2017
SCALE 2:1	DATE 6/30/2017
SHEET 7 OF 19	

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				APPROVED



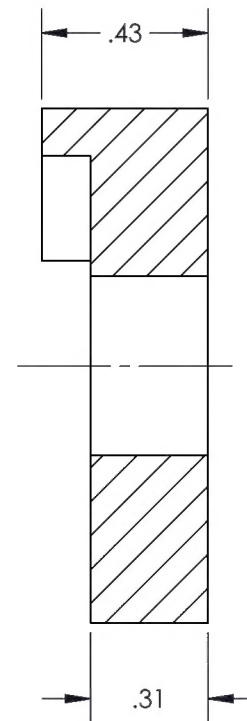
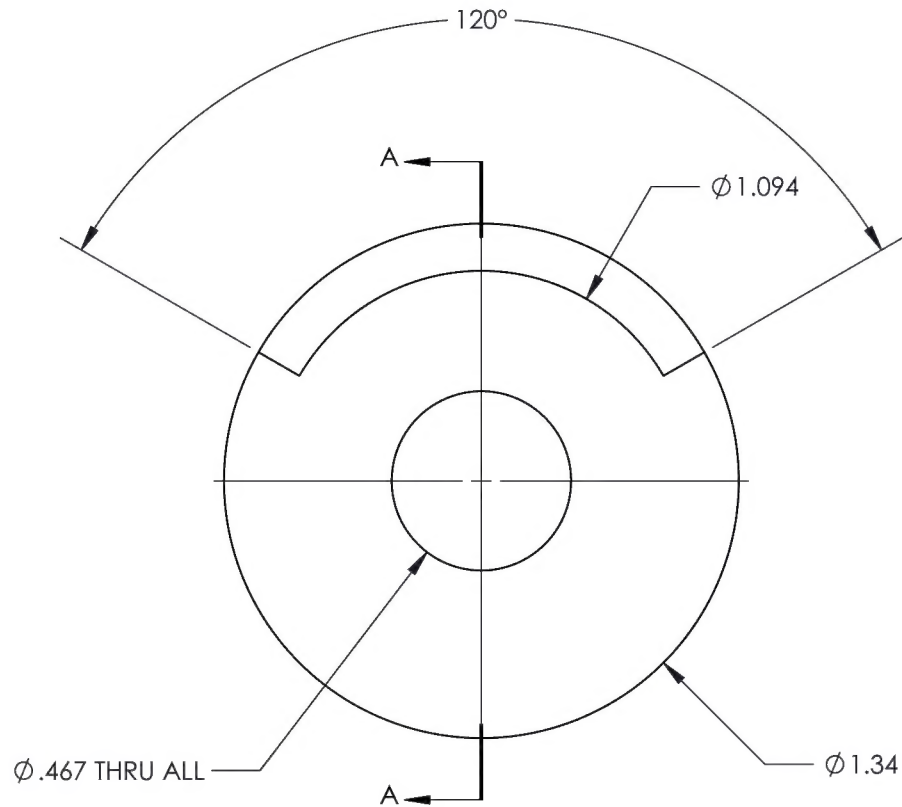
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PLUNGER BASE

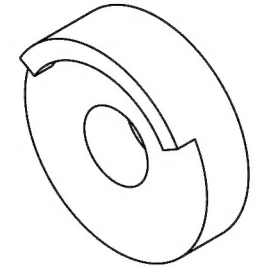
DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-13	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-34	DIMENSIONS ARE IN INCHES
FINISH SEE -11	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DD 06/30/2017	1. BREAK ALL SHARP EDGES
CHECKED: RJC 07/06/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/10/2017	AFTER PLATING
APPROVED: JAG 07/20/2017	3. INTERPRET DIM AND TOL PER
SCALE 2:1	ASME Y14.5M-2009
DATE 6/30/2017	USED ON MODEL
SHEET 8 OF 19	EC145, EC645, BO105, BK117

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				APPROVED



SECTION A-A

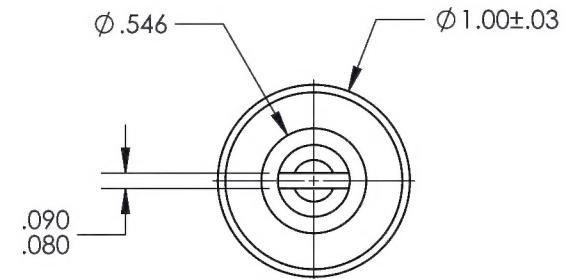
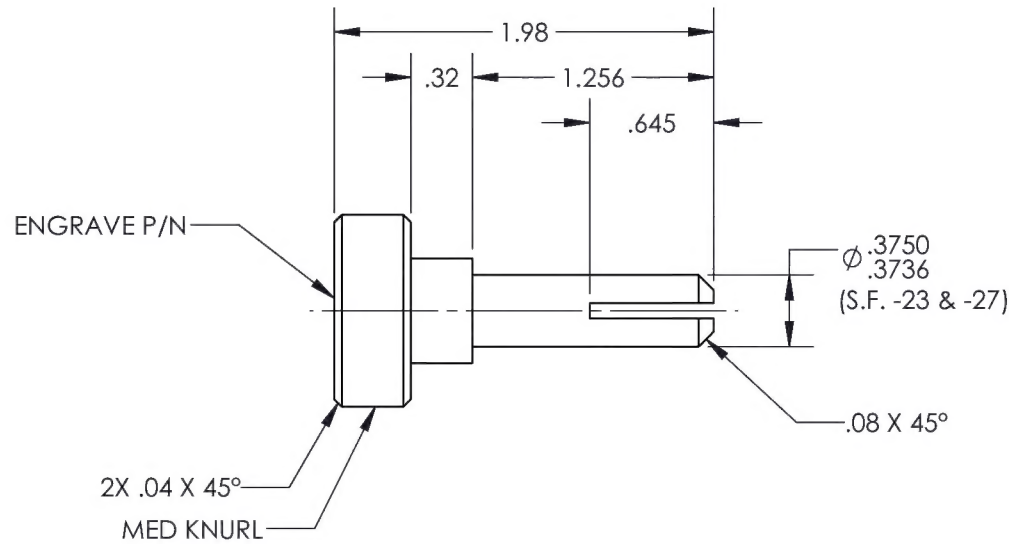
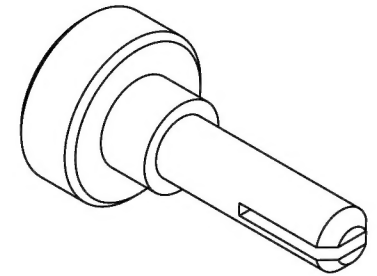


(-15)
SUPPORT DISK

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-15	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
TREAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: DD 06/30/2017	.X ± .1 SURFACES = 125°
CHECKED: RJC 07/06/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/20/2017	AFTER PLATING
SCALE 2:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/30/2017	USED ON MODEL
SHEET 9 OF 19	EC145, EC645, BO105, BK117

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REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

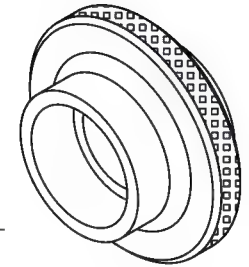
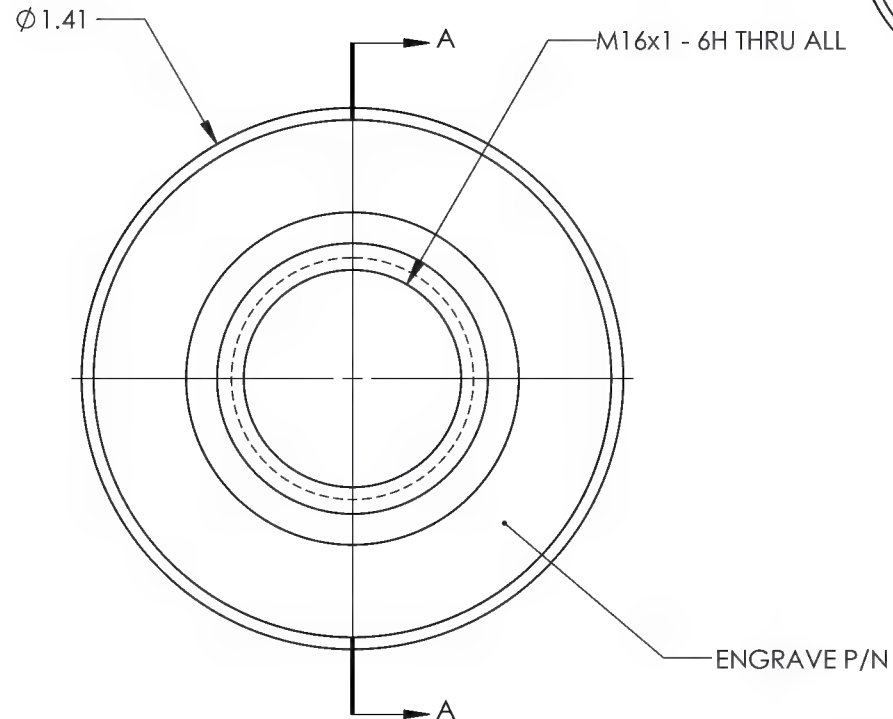
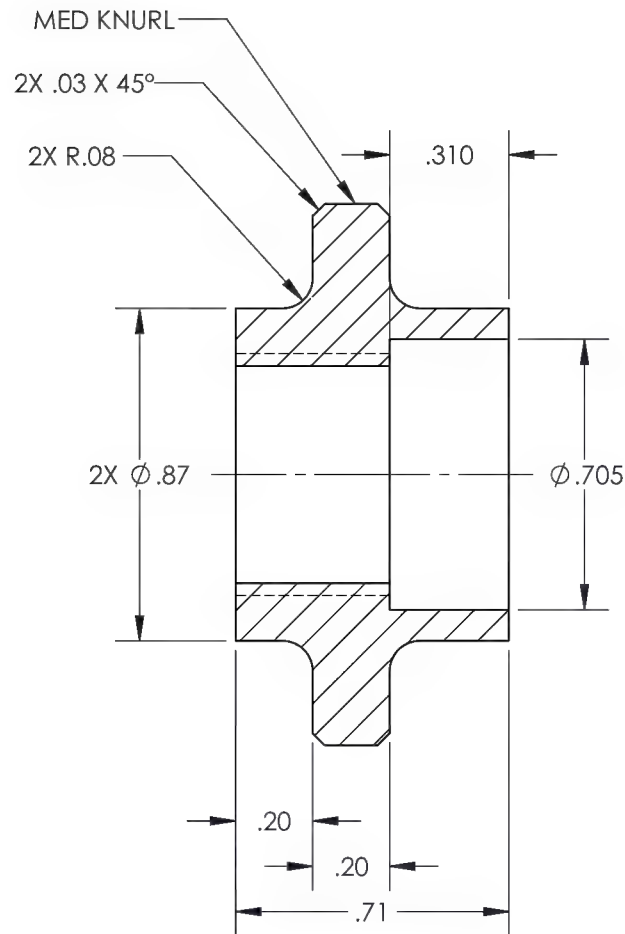


(-17)
PUSHER

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-17	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
DRAWN BY: DD 06/30/2017	.X ± .1 SURFACES = 125°
CHECKED: RJC 07/06/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY
APPROVED: JAG 07/20/2017	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 6/30/2017	USED ON MODEL
SHEET 10 OF 19	EC145, EC645, BO105, BK117

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REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED

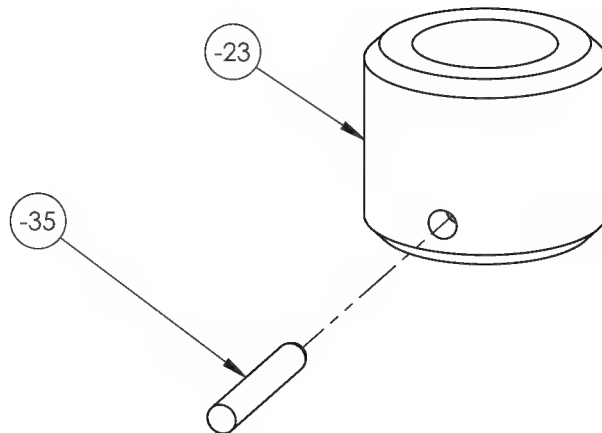
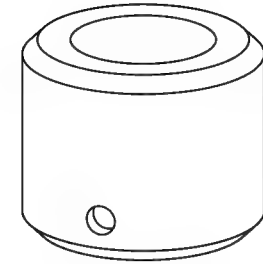


INTERMEDIATE BEARING RING

DART AEROSPACE	
TITLE: PRESSING DEVICE	
DWG NO.: RBE105-42121W4-19	REV: 1
MAT'L: 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT: RC 28-32	DIMENSIONS ARE IN INCHES
FINISH: ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC: ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± .5°
DRAWN BY: DD 06/30/2017	.X ± .1 SURFACES = 125
CHECKED: RJC 07/06/2017	1. BREAK ALL SHARP EDGES
OPPS APPR: AA 07/10/2017	.015 x 45° OR .015R
QA APPR: JL 07/10/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
APPROVED: JAG 07/20/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
SCALE: 2:1	DATE: 6/30/2017
SHEET 11 OF 19	

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				APPROVED



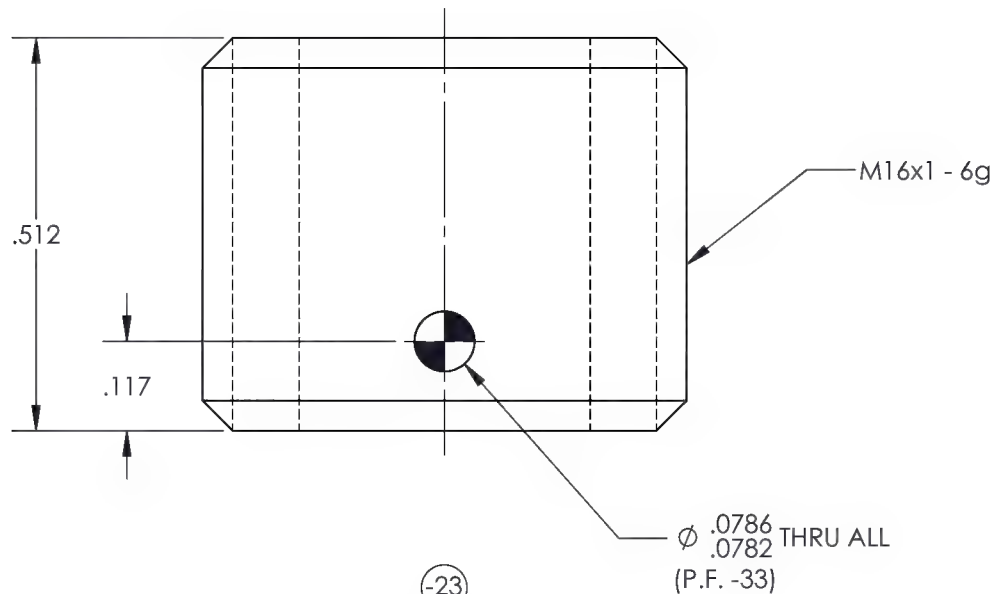
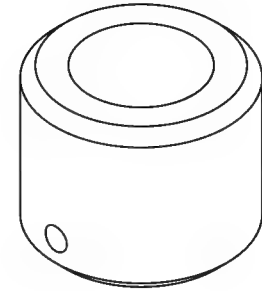
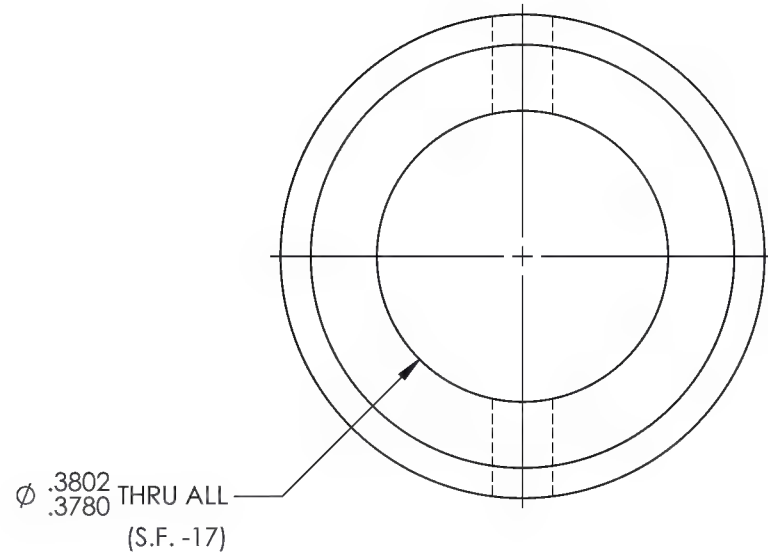
(-21)

13mm GAUGE BLOCK ASSEMBLY

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-21	REV 1
MAT'L ASTM B633 TYPE I SC 2	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES
HEAT TREAT ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
FINISH ZINC PLATE	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 07/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/10/2017	USED ON MODEL
QA APPR: JL 07/10/2017	
APPROVED: JAG 07/20/2017	EC145, EC645, BO105, BK117
SCALE 2:1	DATE 6/30/2017
SHEET 12 OF 19	

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED

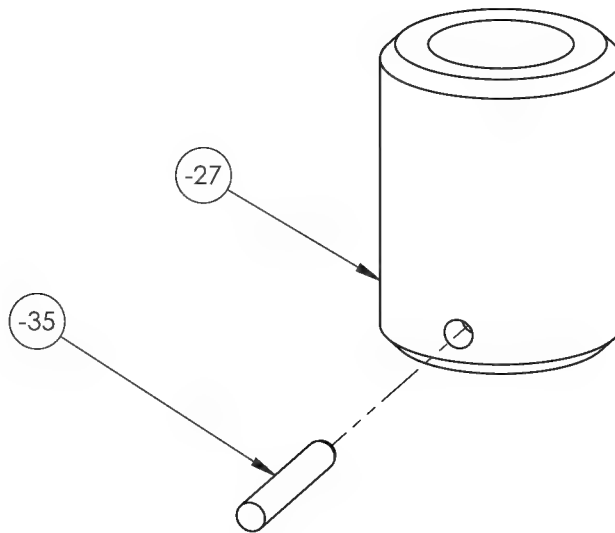
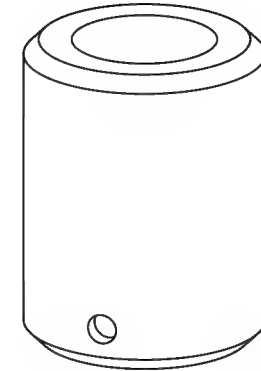


13mm GAUGE BLOCK

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-23	REV 1
MAT'L 4140/4142 HEAT RC 28-32 TREAT FINISH SEE -21 SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DRAWN BY: DD 06/30/2017	USED ON MODEL
CHECKED: RJC 07/06/2017	EC145, EC645, BO105, BK117
OPPS APPR: AA 07/10/2017	
QA APPR: JL 07/10/2017	
APPROVED: JAG 07/20/2017	
SCALE 4:1	DATE 6/30/2017 SHEET 13 OF 19

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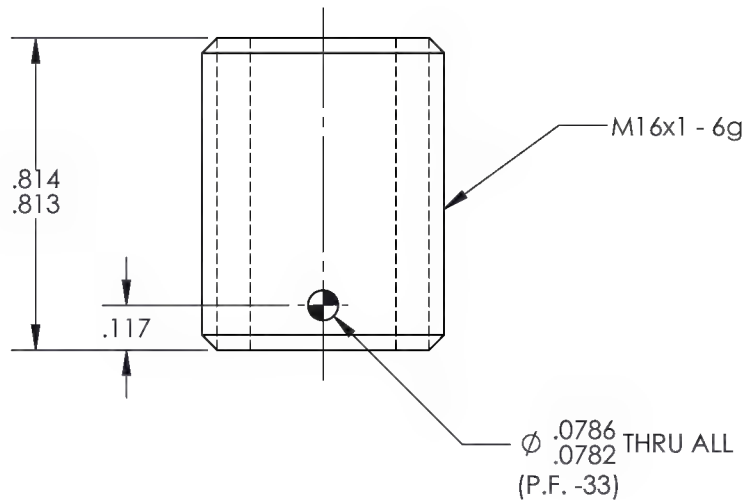
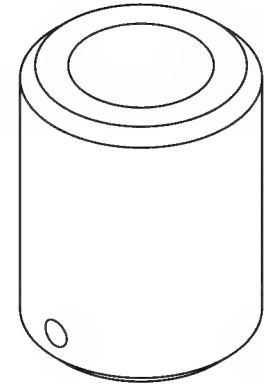
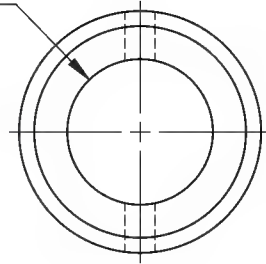
20.65mm GAUGE BLOCK ASSEMBLY

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-25	REV 1
MAT'L HEAT TREAT FINISH ZINC PLATE	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125°
SPEC ASTM B633 TYPE I SC 2	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 07/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/10/2017	USED ON MODEL
QA APPR: JL 07/10/2017	
APPROVED: JAG 07/20/2017	EC145, EC645, BO105, BK117
SCALE 2:1	DATE 6/30/2017
SHEET 14 OF 19	

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REVISIONS			
REV	ECR	DESCRIPTION	DATE

Ø .3802 THRU ALL
.3780
(S.F. -17)



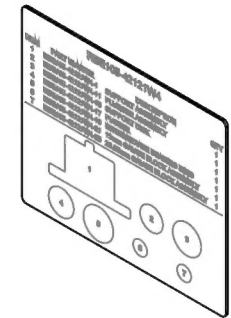
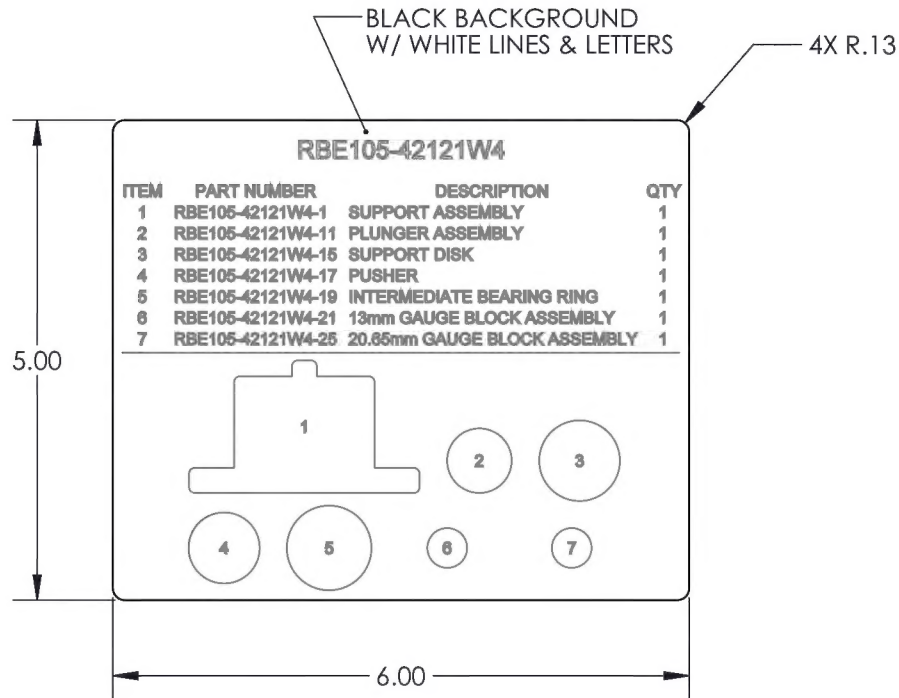
(-27)

20.65mm GAUGE BLOCK

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-27	REV 1
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT RC 28-32	DIMENSIONS ARE IN INCHES
FINISH SEE -25	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DD 06/30/2017	1. BREAK ALL SHARP EDGES
CHECKED: RJC 07/06/2017	.015 x 45° OR .015R
OPPS APPR: AA 07/10/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 07/10/2017	AFTER PLATING
APPROVED: JAG 07/20/2017	3. INTERPRET DIM AND TOL PER
SCALE 2:1	ASME Y14.5M-2009
DATE 6/30/2017	USED ON MODEL
SHEET 15 OF 19	EC145, EC645, BO105, BK117

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			INITIAL
			APPROVED



NOTE:
USE PDF.

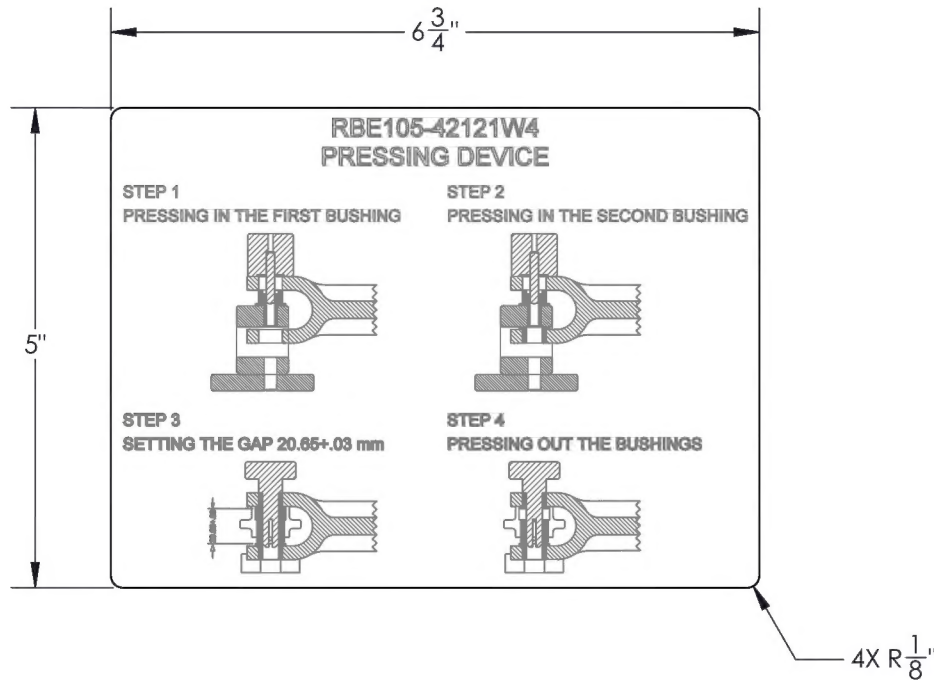
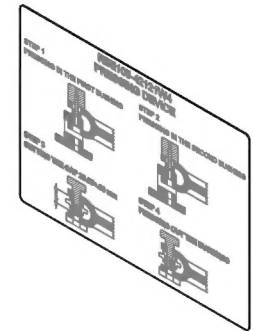
DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-29	REV 1
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
DRAWN BY: DD 06/30/2017	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: RJC 07/06/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: AA 07/10/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: JL 07/10/2017	USED ON MODEL
APPROVED: JAG 07/20/2017	EC145, EC645, BO105, BK117
SCALE 1:2	DATE 6/30/2017 SHEET 16 OF 19

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CONTENTS PLACARD

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NOTE:
USE PDF.

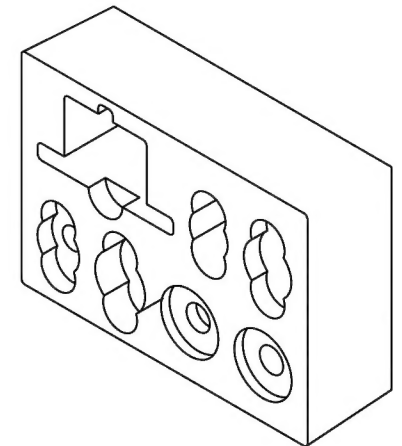
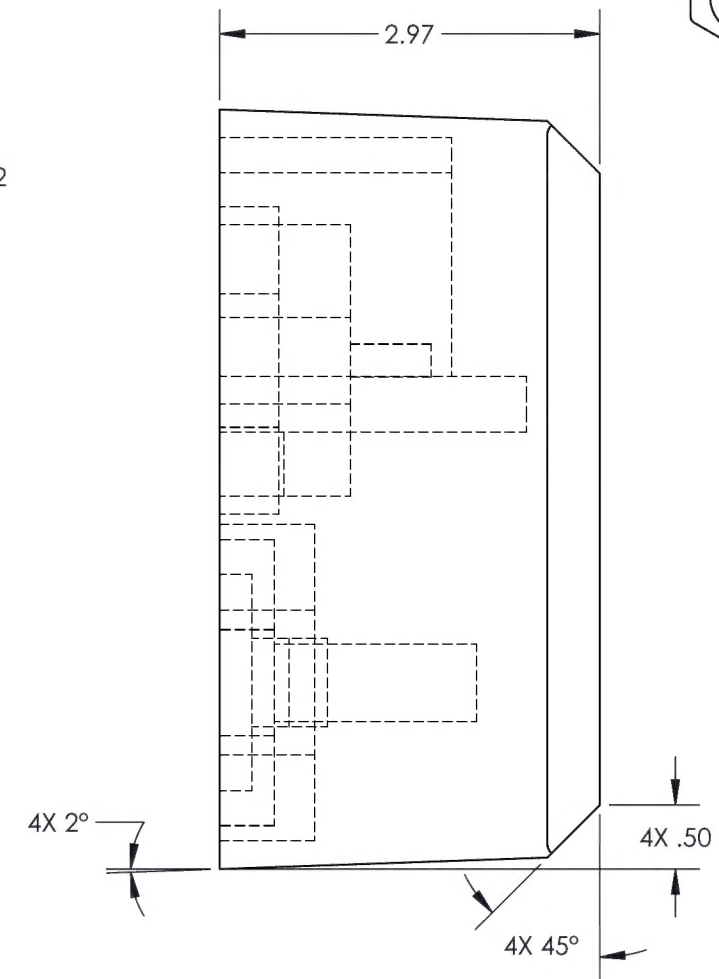


TITLE		PRESSING DEVICE	
DWG NO.		RBE105-42121W4-31	REV 1
MAT'L LAMINATED PAPER		UNLESS OTHERWISE SPECIFIED	
HEAT TREAT FINISH		DIMENSIONS ARE IN INCHES	
SPEC		.XXX ± .005 FRACTIONS ± 1/8	
DRAWN BY: DD 06/30/2017		.XX ± .01 ANGLES ± 5°	
CHECKED: RJC 07/06/2017		.X ± .1 SURFACES = 125°	
OPPS APPR: AA 07/10/2017		1. BREAK ALL SHARP EDGES	
QA APPR: JL 07/10/2017		.015 x 45° OR .015R	
APPROVED: JAG 07/20/2017		2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE 1:2		3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DATE 06/30/2017		USED ON MODEL	
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INSTRUCTION CARD

REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED

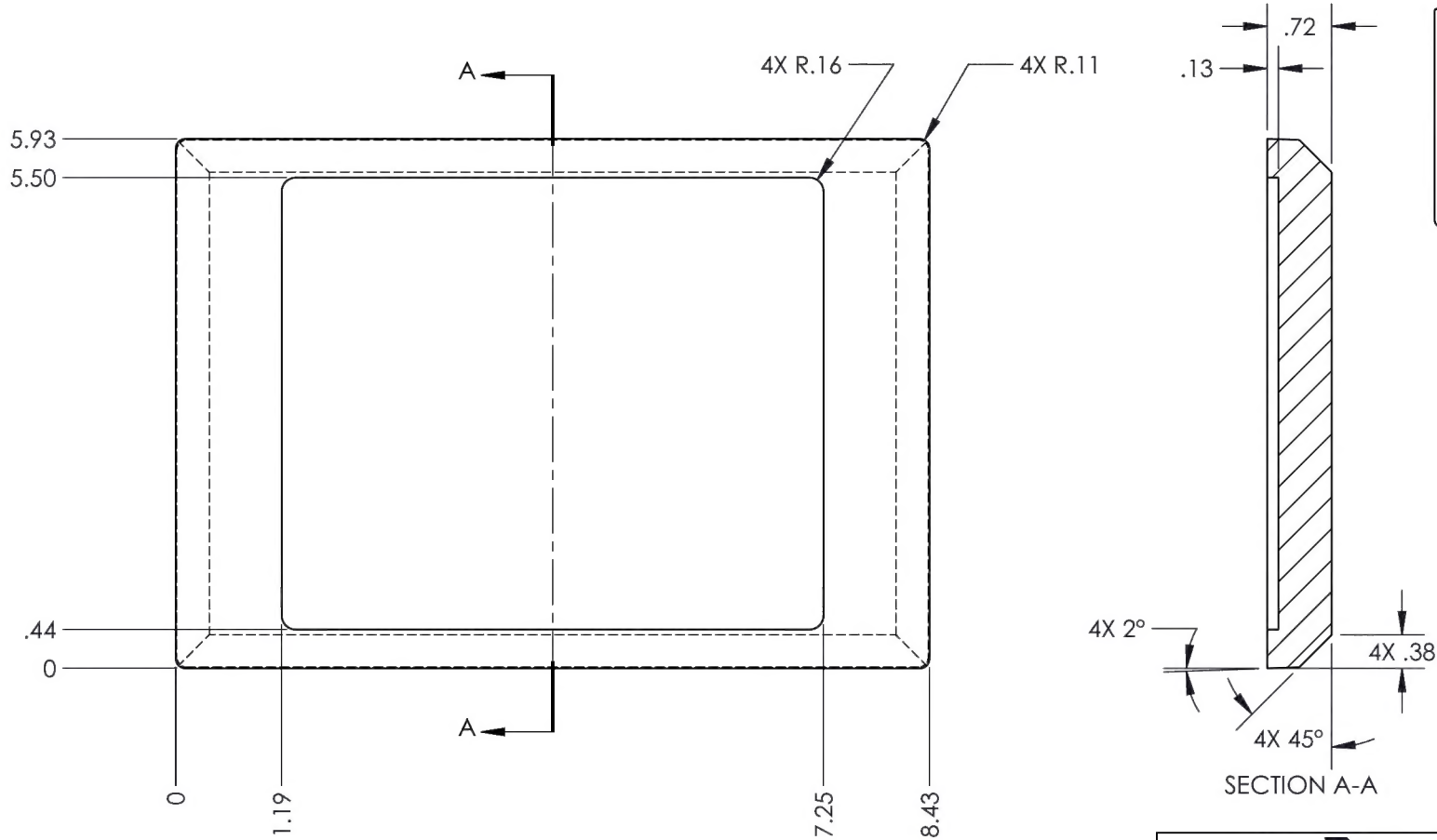


BOTTOM FOAM

			
TITLE			
PRESSING DEVICE			
DWG NO.			REV
RBE105-42121W4-37			1
MAT'L ETHAFOAM 220, BLACK		UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
HEAT TREAT		.XXX \pm .010 FRACTIONS \pm 1/8 .XX \pm .03 ANGLES \pm 1° .X \pm .1 SURFACES = 125/√	
FINISH			
SPEC		1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	
DRAWN BY:	DD 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
CHECKED:	RJC 07/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
OPPS APPR:	AA 07/10/2017	USED ON MODEL	
QA APPR:	JL 07/10/2017		
APPROVED:	JAG 07/20/2017	EC145, EC645, BO105, BK117	
SCALE	2:3	DATE	6/30/2017
		SHEET 18 OF 19	

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SECTION A-A

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TOP FOAM

DART AEROSPACE	
TITLE PRESSING DEVICE	
DWG NO. RBE105-42121W4-39	REV 1
MAT'L ETHAFOAM 220, BLACK	
HEAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .010 FRACTIONS ± 1/8 .XX ± .03 ANGLES ± 1° .X ± .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: DD 06/30/2017	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: RJC 07/06/2017	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: AA 07/10/2017	USED ON MODEL
QA APPR: JL 07/10/2017	EC145, EC645, BO105, BK117
APPROVED: JAG 07/20/2017	
SCALE 1:2	DATE 6/30/2017 SHEET 19 OF 19